



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

✓ D2573

Job Sheet 196009



Part No: D2573

Job Qty: 12 pcs ✓

Part Name: Saddle, Aft, Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/4/19

Job Tracking No:

Due Date: 6/12/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV F IPP: I As Per RevE 06-01-27 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Machining - Issue SN	12 pcs	6/12/19		0.00	0.00	HAAS - 1		
							HAAS - 2		
							HAAS - 3		SBL 19/06/19
							HAAS - 4		
100	HAAS 4 Axis - B4B	12 pcs	6/12/19		1.00	19.35	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		VH8 19/06/25
							HAAS - 4 - B4B		
110	Conventional Mill - 1 - B4B	12 pcs	6/12/19		0.00	2.00	Conventional Mill - 1 - B4B		VH8 19/6/25
							Conventional Mill - 2 - B4B		
120	QC 2	12 pcs	6/12/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		VH8 19/6/25
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		



Container No: S192087



Part: D2573

Job No: 196009

Serial No/Batch: S192087

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
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Email: sales@dartaero.com
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Date: 06/19/19

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				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130 QC 8	12 pcs	6/12/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	mml 12/06/20
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
140 Handfinish - 1-1 Chemical-B4B	12 pcs	6/12/19	0.00 0.56	Handfinish - 1 - 1 - B4B	BEB 19-06-28
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	

					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White Gl(A)- B4B	12 pcs	6/12/19	0.00 0.46	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
160	QC 3	12 pcs	6/12/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
170	Packaging 3-1 - Stock - B4B	12 pcs	6/12/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	

					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180 QC 21 - SA	12 pcs	6/12/19	0.00	0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	3-88 JUL 09 2019

Part Op **100** - (HAAS CNC vertical machine #1) Program Batch No. _____
 Descriptions: **110** - (Manufacture as per dwg) Machine keyway as per dwg D2573 & D2574
130 - (QC8- Inspect parts - second check)
140 - (Chemical Conversion Coat per QSI005 4.1)
150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____
160 - (QC3- Inspect Part Finish)
170 - (Identify as per dwg & Stock Location: _____)
180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	12 pcs (1 ea)	100-HAAS 4 Axis - B4B	S184713

Job Allocations

Operation	Component Part	Required
100-HAAS 4 Axis - B4B	D6101-007	12

S192085

OK

Part Specifications

Spec No	Description	Target/Tolerance	Limits	T
1	Saddle, Aft Outboard	0.438Inches + 0.005 - 0.000	0.443 0.438	
2	Saddle, Aft Outboard	1.745Inches + 0.010 - 0.000	1.755 1.745	
3	Saddle, Aft Outboard	3.495Inches + 0.010 - 0.000	3.505 3.495	
4	Saddle, Aft Outboard	1.745Inches + 0.010 - 0.000	1.755 1.745	
5	Saddle, Aft Outboard	7.990Inches + 0.020 - 0.000	8.010 7.990	
6	Saddle, Aft Outboard	0.490Inches + 0.020 - 0.000	0.510 0.490	
7	Saddle, Aft Outboard	0.257Inches + 0.005 - 0.000	0.262 0.257	
8	Saddle, Aft Outboard	0.375Inches + 0.005 - 0.000	0.380 0.375	
9	Saddle, Aft Outboard	0.490Inches + 0.020 - 0.000	0.510 0.490	
10	Saddle, Aft Outboard	1.174Inches + 0.010 - 0.000	1.184 1.174	
11	Saddle, Aft Outboard	0.558Inches + 0.020 - 0.000	0.578 0.558	
12	Saddle, Aft Outboard	1.174Inches + 0.010 - 0.000	1.184 1.174	

13	Saddle, Aft Outboard	1.365Inches	+ 0.010 - 0.000	1.375 1.365
14	Saddle, Aft Outboard	2.495Inches	+ 0.010 - 0.000	2.505 2.495
15	Saddle, Aft Outboard	4.119Inches	+ 0.010 - 0.000	4.129 4.119
16	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
17	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
18	Saddle, Aft Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Aft Outboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Aft Outboard	3.210Inches	+ 0.040 - 0.000	3.250 3.210
22	Saddle, Aft Outboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Aft Outboard	0.308Inches	+ 0.005 - 0.000	0.313 0.308
25	Saddle, Aft Outboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Aft Outboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Aft Outboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Aft Outboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Aft Outboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Aft Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Aft Outboard	1.500Inches	+ 0.020 - 0.000	1.520 1.500
32	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Aft Outboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Aft Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Aft Outboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Aft Outboard	0.023Inches	+ 0.020 - 0.000	0.043 0.023

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD	Work Order: 196 009
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.000	8.000	8.000		
F	0.490	0.510		0.505	0.503	0.501	0.502		
G	0.257	0.262		0.257	0.259	0.257	0.257		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.502	0.502	0.502	0.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.570	0.570	0.569	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.129	4.129	4.129	4.129		
P	0.115	0.135		0.125	0.125	0.125	0.125		
Q	0.115	0.135		0.135	0.135	0.125	0.125		
R	0.240	0.260		0.250	0.250	0.250	0.250		
S	0.115	0.135		0.128	0.129	0.129	0.129		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.240	0.241	0.241	0.242		
W	0.115	0.135		0.1275	0.126	0.128	0.129		
X	0.308	0.313		0.317	0.311	0.311	0.312		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.363	0.364	0.364	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.620	0.620	0.627		
AC	0.053	0.073		0.063	0.061	0.062	0.066		
AD	0.240	0.260		0.251	0.253	0.253	0.254		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		0.135	0.135	0.133	0.128		
AG	0.240	0.280		0.260	0.260	0.250	0.250		
AH	0.240	0.260		0.260	0.260	0.260	0.260		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: <i>VHJ</i>	Audited by: <i>mmc</i>
Date: 19/6/20	Date: 19/06/20

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 196 009
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	26	37	48		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.501	.501	.500	.502		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.501	.501	.502	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.569	.569	.569	.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.135	.133	.136	.137		
Q	0.115	0.135		.125	.126	.126	.126		
R	0.240	0.260		.252	.252	.252	.252		
S	0.115	0.135		.129	.128	.128	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.242	.242	.242	.241		
W	0.115	0.135		.130	.129	.130	.130		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.364	.364	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.626	.627	.627		
AC	0.053	0.073		.062	.062	.066	.066		
AD	0.240	0.260		.253	.254	.254	.254		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		.124	.123	.124	.127		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.252	.253	.253	.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	
Date:	

Audited by:	507mm L
Date:	19/06/20

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 1960 009
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				#9	#10	#11	#12		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.501	.500	.501	.500		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.501	.502	.502	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.570	.570	.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.133	.135	.135	.135		
Q	0.115	0.135		.126	.125	.126	.126		
R	0.240	0.260		.252	.252	.252	.252		
S	0.115	0.135		.129	.129	.129	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.241	.241	.242	.241		
W	0.115	0.135		.130	.128	.128	.129		
X	0.308	0.313		.311	.311	.311			
Y	0.760	0.765		.760	.760	.760			
Z	0.352	0.372		.366	.363	.363	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.626	.627	.627		
AC	0.053	0.073		.066	.065	.066	.066		
AD	0.240	0.260		.253	.253	.252	.252		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		.122	.122	.124	.124		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.252	.252	.252	.252		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	
Date:	

Audited by:	mmc
Date:	14/06/24

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	